

Date: Thursday, 07/08/2008 4:23:24 PM  
User: Julie Lecocq

## Process Sheet

SPLIT - 2

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: ARM	
Job Number	: 41068			Part Number	: D3560043	
Estimate Number	: 12883			Drawing Number	: D3560 REV D	
P.O. Number	:			Project Number	: N/A	
This Issue	: 07/08/2008	S.O. No.	:	Drawing Revision	: D	
Prsht Rev.	: NC			Material	:	
First Issue	: / /	Type	: MACHINED PARTS	Due Date	: 26/08/2008	
Previous Run	: 40300			Qty:	10 Um: Each	
Written By	:					
Checked & Approved By	: JLP 08.8.08					
Comment	: Est Rev:A New Issue 07.05.24 EC					
	Est Rev B ECN 987 07.10.09 EC					
	Est Rev:C ECN1048 07-12-18 DD verified by: EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	M6061T6B0500X05000	6061-T6 Bar .500 x 5.00	
		Comment: Qty.: 1.3598 f(s)/Unit Total: 13.5975 f(s) 6061-T6 Bar 0.50" x 5.00"	
		Batch: W/08854	JL 08/08/24
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks 15.500" long	JL 08/08/24
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1	
		1- Mill as per Folio FA695 Rev: AA & Dwg D3560 Rev: D	
		2-C'sink 0.196" hole on manual mill as per dwg D3560	
		3-Deburr per dwg D3560	JLP 08/08/26
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	JLP 08/08/27



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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK



SD 08/09/02 (2)

6.0 D35921 Plate



Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

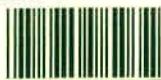
PLATE

B 42279

SP 08.09.30

(2x)

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

STEP:

- 1- clean material (buff bracket and bottom of arm with blue pad ) SP
- 2- set up bracket and arm on jig SP
- 3- preheat bracket and arm with torch SP
- 4- clean before welding with brush SP
- 5- set up machine to 135 amps SP SP
- 6- weld across bottom and top ends SP
- 7- reheat with torch ( 65 deg C ) SP
- 8- on one side weld from bottom to top half way SP
- 9- same for other side (half way) SP
- 10- from half way point weld the rest of the first side (ease off pedal near end) SP
- 11- same for remaining side (ease off pedal near end) SP

SP 08-09.30 (2x)

8.0 QC5 INSPECT WORK TO CURRENT STEP



J 08-10-01 (2)

Comment: INSPECT WORK TO CURRENT STEP

9.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-09-30 (2)

10.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Mf

08-10-01

(2x)



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Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(2x)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-f 08/10/02

12.0 D2808

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Spacer  
batch: B37113

Sp 08/10/02 (2)

13.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press bushing in D3560 arm per dwg D3562

Sp 08/10/02 (2)

14.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/02 (2)

15.0 PACKAGING 1

PACKAGING RESOURCE #1



(2x)

Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: 150

8/10/02

SL

16.0 QC21

FINAL INSPECTION/W/O RELEASE



08/10/03 H

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08/10/03



DART AEROSPACE LTD	Work Order:	41068
Description: Arm	Part Number:	D3560-3
Inspection Dwg: D3560	Rev: B	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

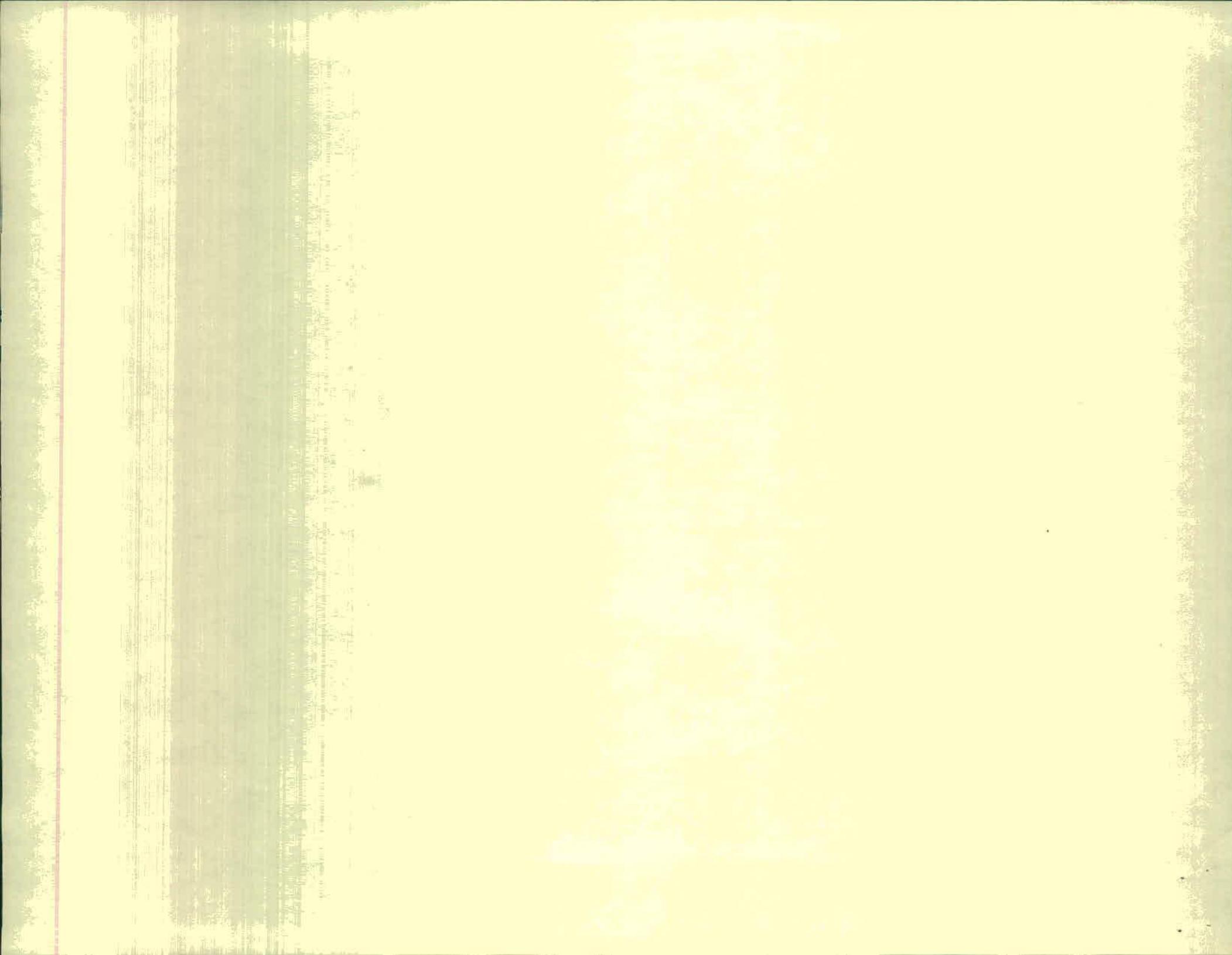
## X First Article      Prototype

Measured by: DIP  
Date: 08/08/26

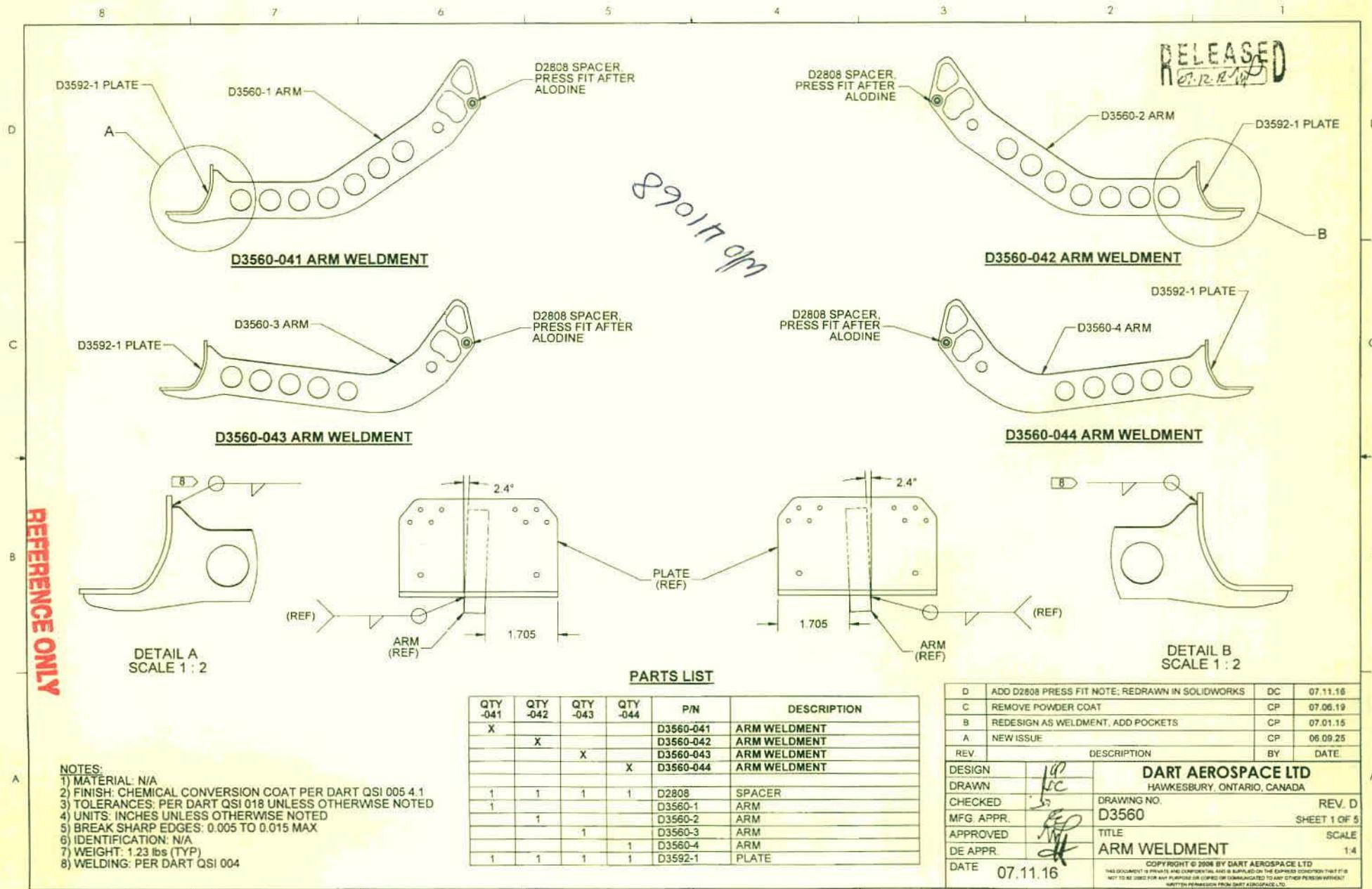
Audited by:	SJ
Date:	5/10/22

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	EZ

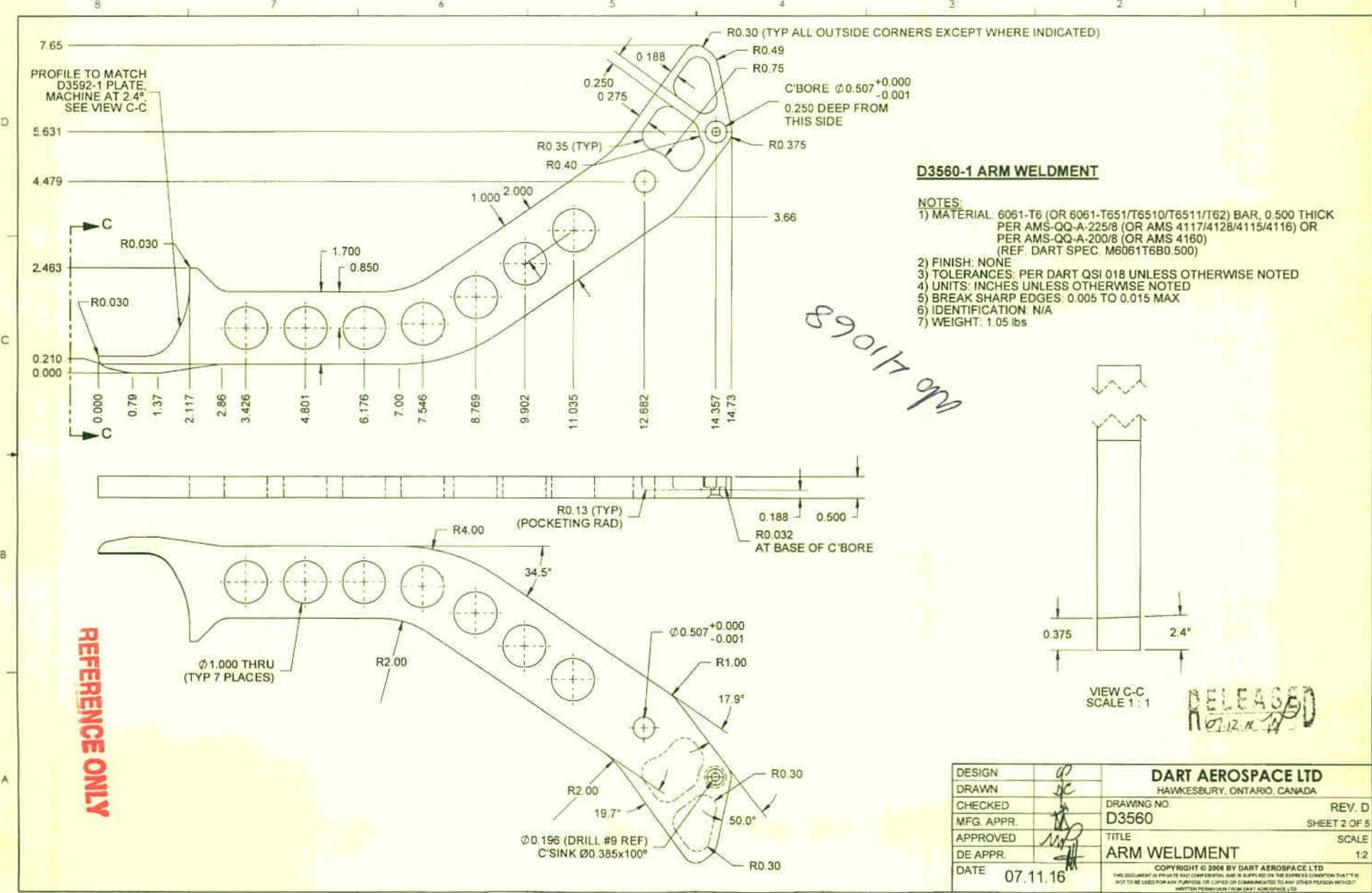


REFERENCE ONLY



ÜBERBLICK OMA

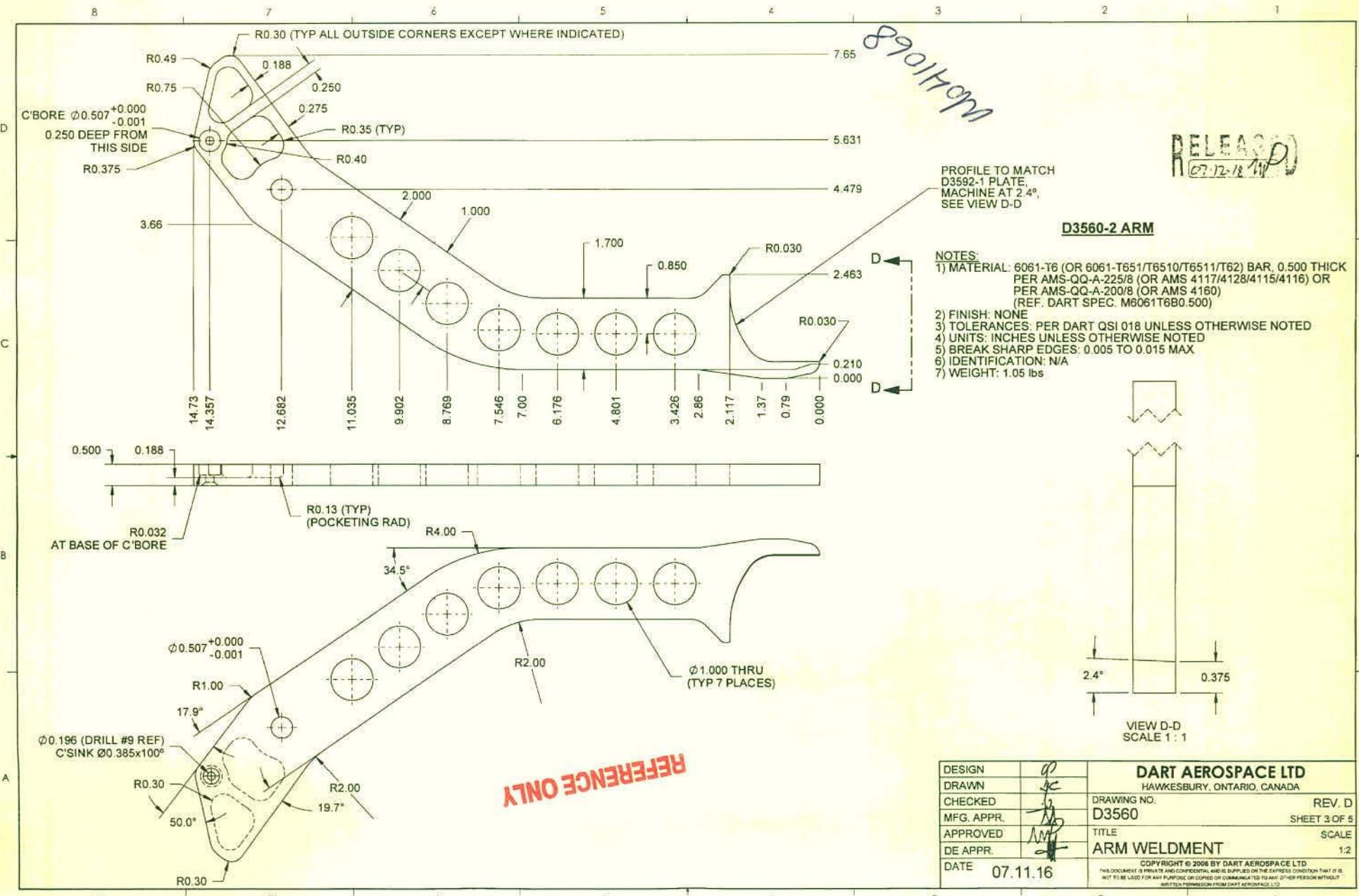
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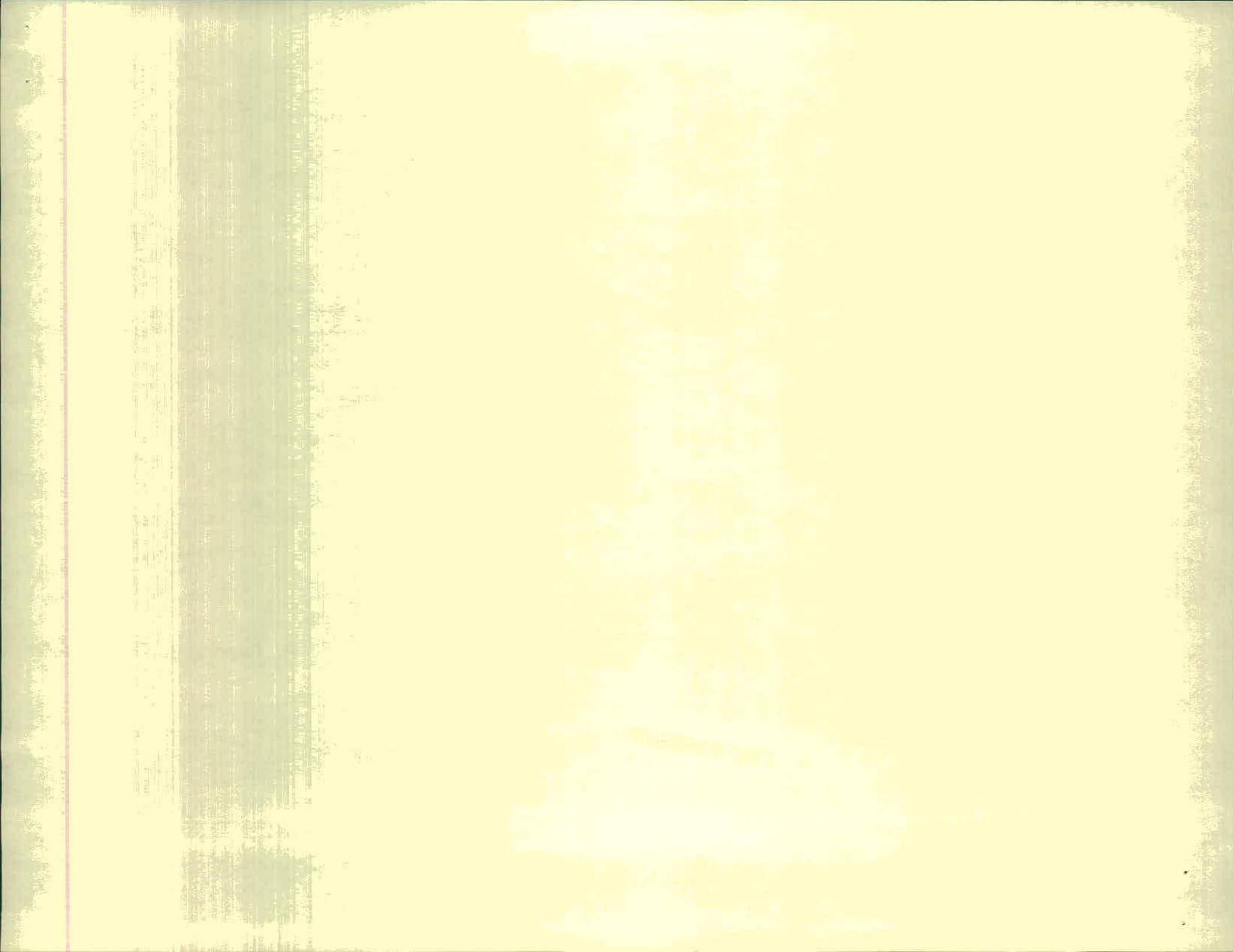
## TESTIMONY

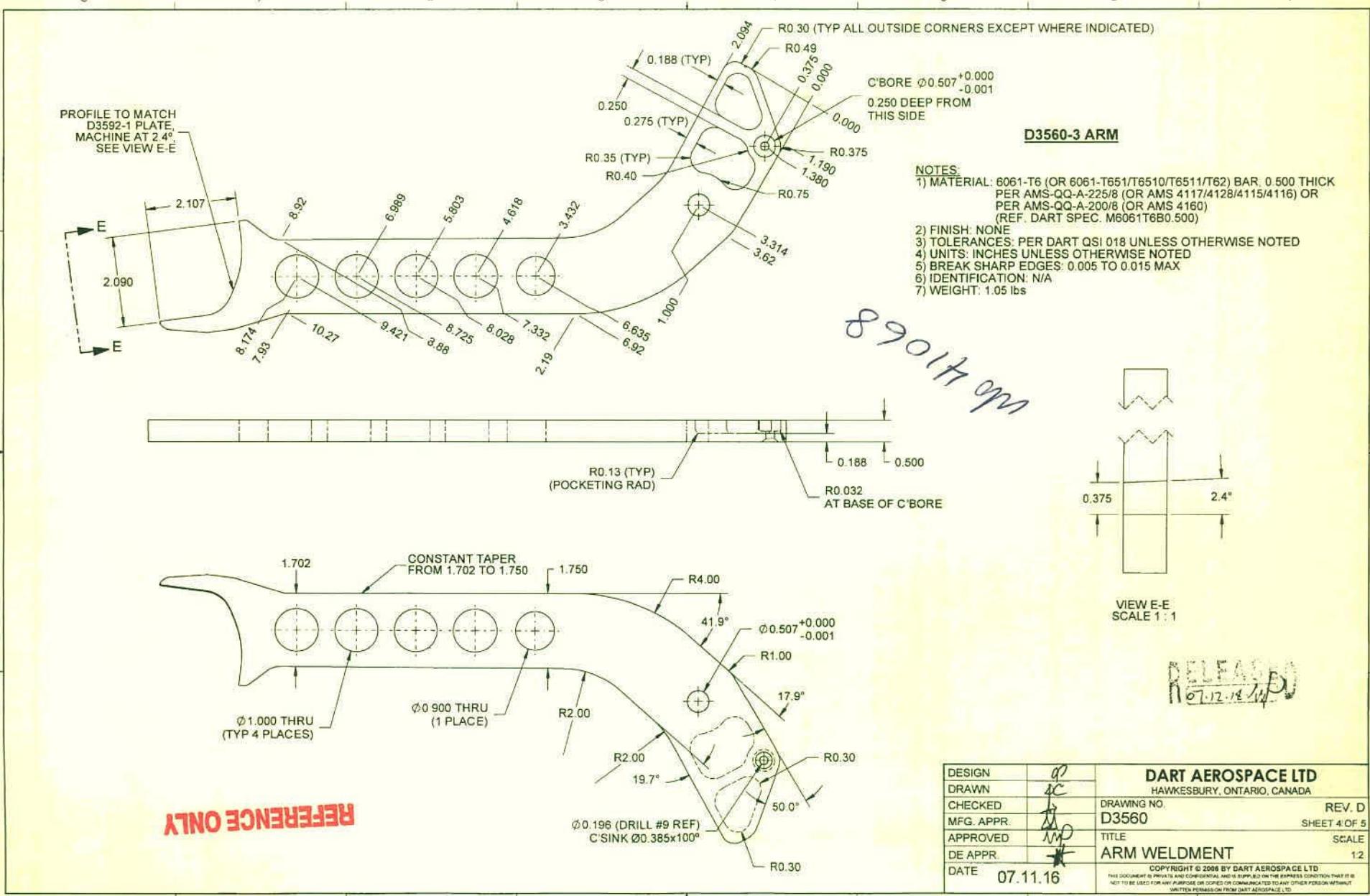
John H. Smith, of New York, N.Y., was present at the trial.

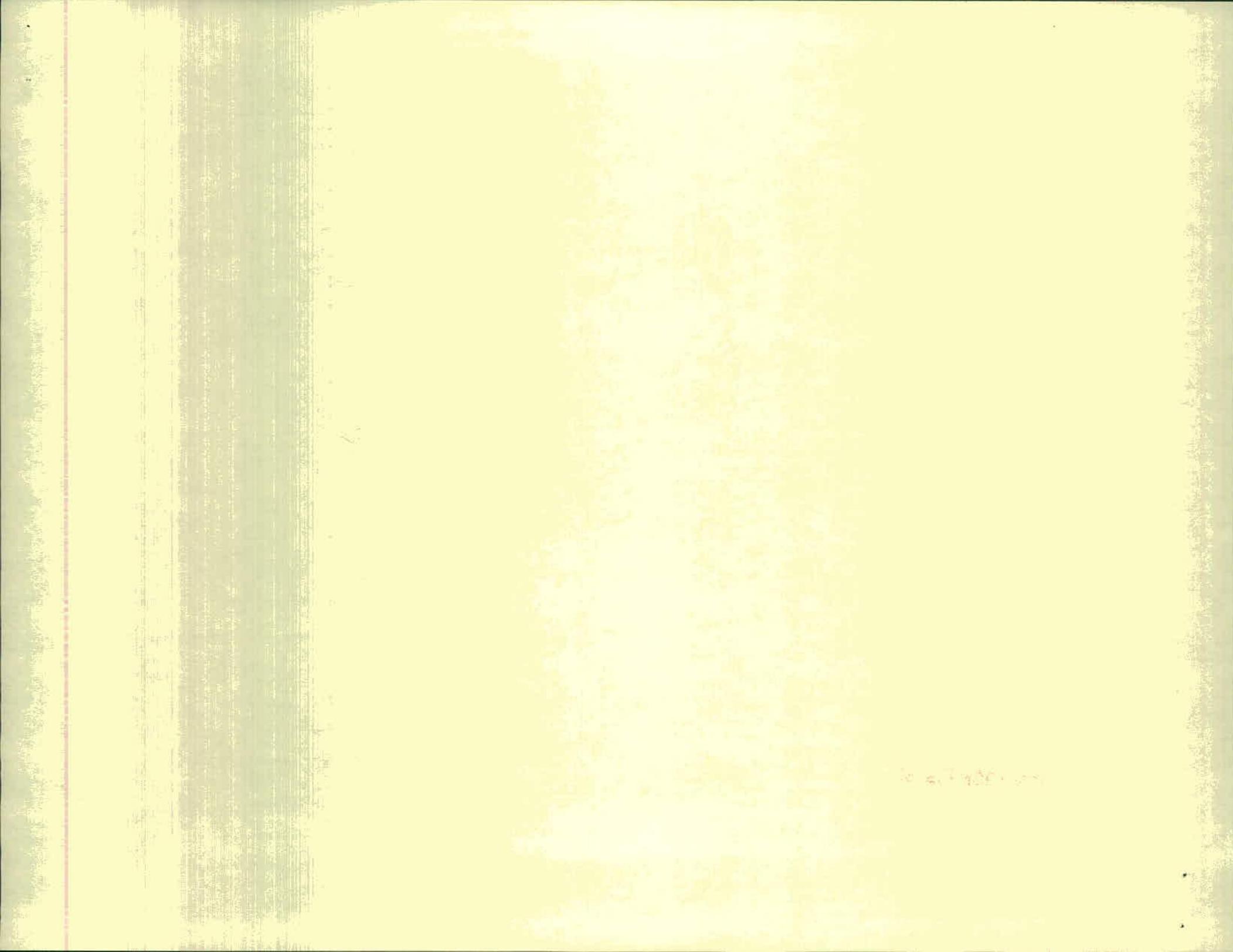
10

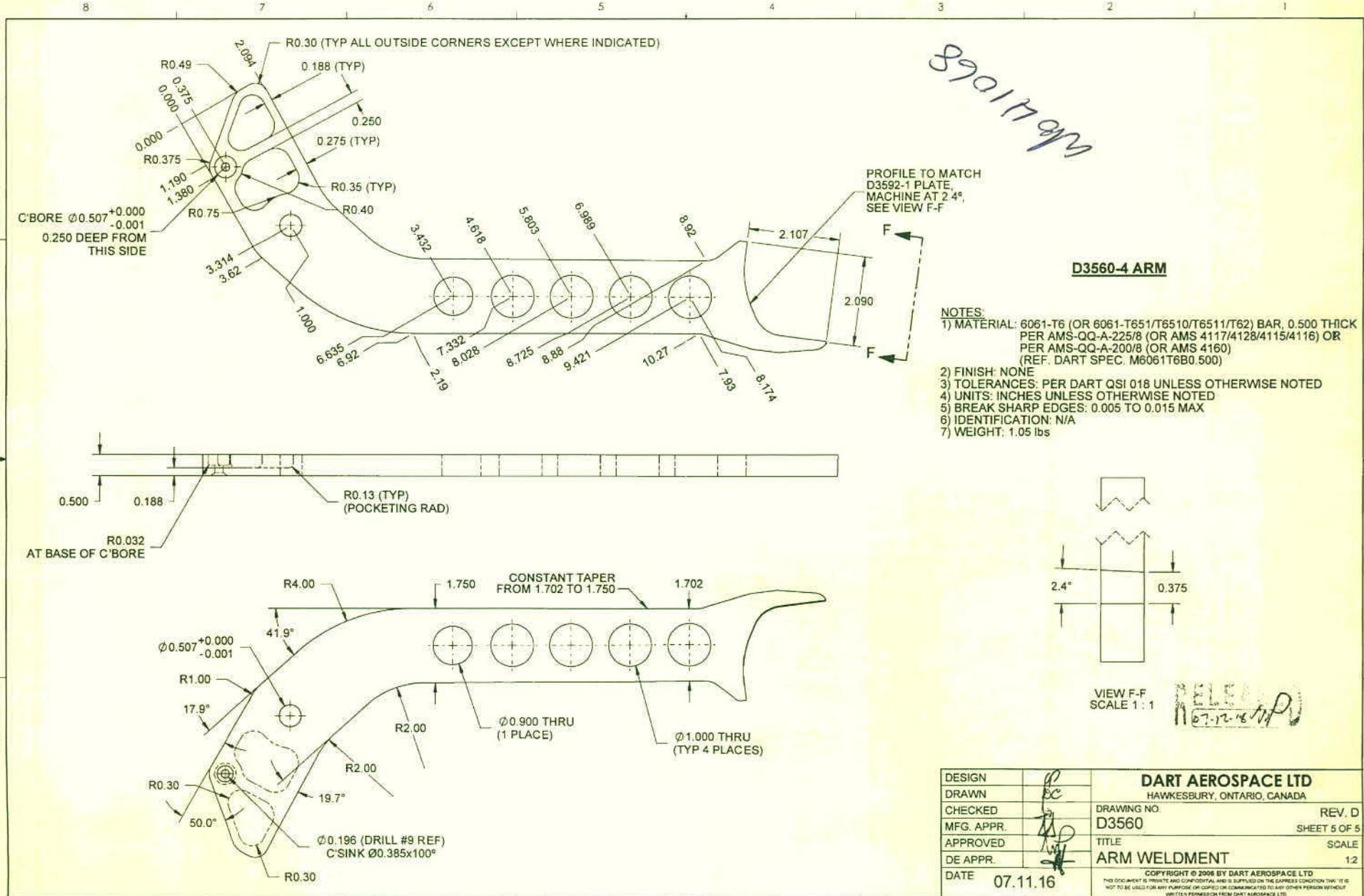


DESIGN	<i>Q</i>	DART AEROSPACE LTD	
DRAWN	<i>SC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JL</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>AD</i>	D3560	SHEET 3 OF 5
APPROVED	<i>MF</i>	TITLE	SCALE
DE APPR.	<i>MF</i>	ARM WELDMENT	1:2
DATE	07.11.16	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND IS RESTRICTED TO THE USE FOR WHICH IT WAS PROVIDED. IT IS NOT TO BE USED OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	









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